

SPLIT

Date: Wednesday, 12/13/2006 2:47:58 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 29937
Estimate Number : 10440
P.O. Number : *NA*
This Issue : 12/13/2006 S.O. No. : *NA*
Prsht Rev. : NC
First Issue : *NA* Type : MACHINED PARTS
Previous Run : 28225
Drawing Name : FUEL PURGE CANISTER
Part Number : D3262041
Drawing Number : D3262 REV C
Project Number : N/A
Drawing Revision : C
Material : *NA*
Due Date : 1/10/2007 Qty: 6 Um: Each
Written By : *[Signature]*
Checked & Approved By : *[Signature]*
Comment : Est. C 05.03.10 Removed P/O for liquid penetrant inspection K
J/JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 29937A FUEL PURGE CANISTER



Comment: Sub-Component FUEL PURGE CANISTER

D3262-1 B

28225A



28225A

(2P)

BE 07-10-03

2.0 29937B FUEL PURGE CANISTER



Comment: Sub-Component FUEL PURGE CANISTER

D3262-3 B

28225



28225B

(PR)

BE 07-10-03

3.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld canister assembly as per Dwg D3262 using DT8739 to align fillings

Pick: Qty

Part Number

Description

Batch

A/R

Aluminum Rod

M103794

M105058

BE 07-10-03

BE 07-05-08

4.0 QC5/9 WELD INSPECTION



QC #5
QC #7

Sp M10603
PD 07-10-03

Tested under water for leaks

Comment: WELD INSPECTION

Pressure test as per Dwg D3262

M 07/05/09

5.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



(4X)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-L
M-L

07/05/09

07/10/03

(2X)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FUEL PURGE CANISTER

Job Number: 29937

Part Number: D3262041

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

POWDER COATING

POWDER COATING



M103706



Comment: POWDER COATING

1-Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3

2-Ensure to mask threads

OKA

M105068

X2

07-10-03

07-05-09 (4)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-A

07/05/09

4X Copy (2)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N as per Dwg using a permanent fine point marker, then Stock

Location: _____

07/10/04 (4)

07/10/04 (2)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/10/04 (2)

Job Completion:

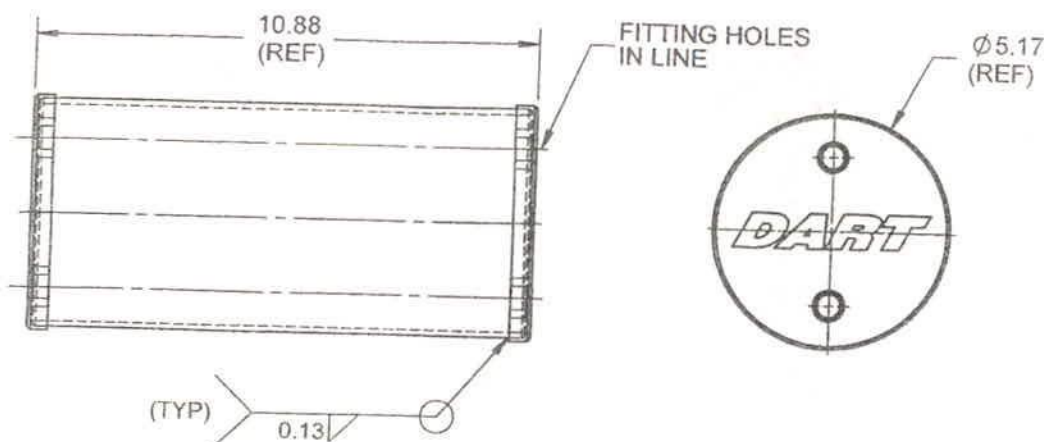


07-10-04

DART

DESIGN <i>PH</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>H</i>	DRAWING NO. D3262	REV. C
DATE 06.08.31		TITLE FUEL PURGE CANISTER	SHEET 1 OF 2
			SCALE 1:4
REV	DATE	DESCRIPTION	
A	04.05.06	FIRST ISSUE	
B	05.02.14	ADD PRESSURE TESTING OPTION	
C	06.08.31	Ø 5.165 WAS Ø 5.190	

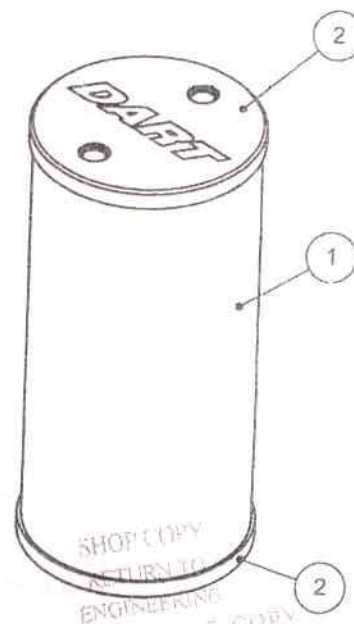
RELEASED

06-09-19 *H***D3262-041 CANISTER ASSEMBLY**

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3362-041	CANISTER ASSEMBLY
1	1	D3262-1	TUBE
2	2	D3262-3	CAP

NOTES:

- 1) WELD PER DART QSI 004
- 2) BREAK ALL SHARP CORNERS 0.005 TO 0.010
- 3) LIQUID PENETRANT INSPECT PER ASTM E1417 LEVEL 1 OR PRESSURIZE TO 10 psi AND SUBMERGE UNDER WATER TO CHECK FOR LEAKS **B**
- 4) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1 POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 7) IDENTIFY WITH DART P/N AND B/N USING FINE POINT PERMANENT INK MARKER



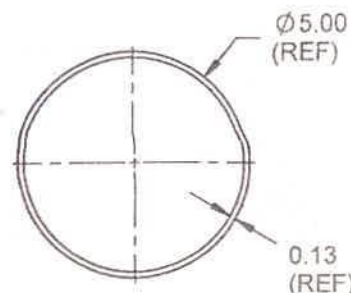
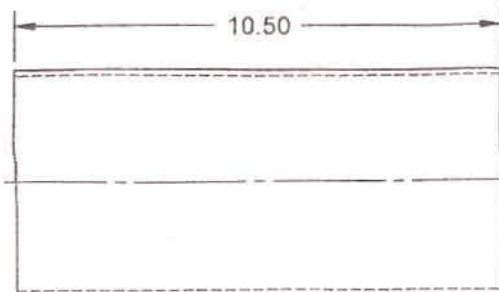
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NO. 29937

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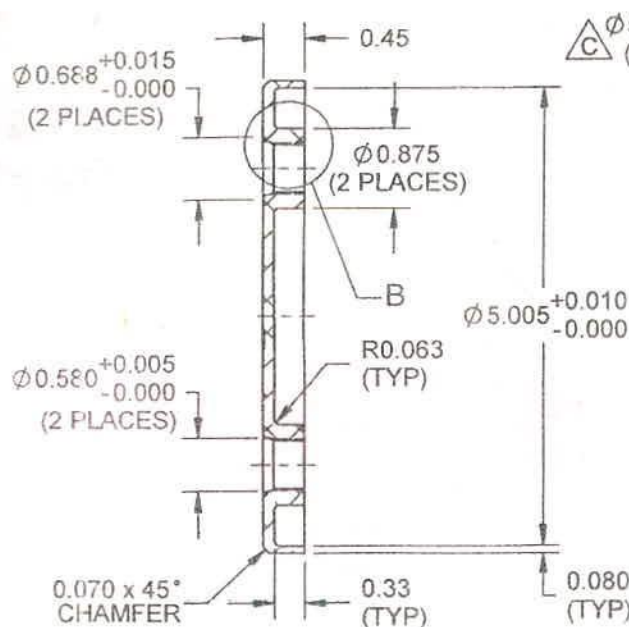
DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3262	REV. C SHEET 2 OF 2
DATE 06.08.31	TITLE FUEL PURGE CANISTER		SCALE 1:4



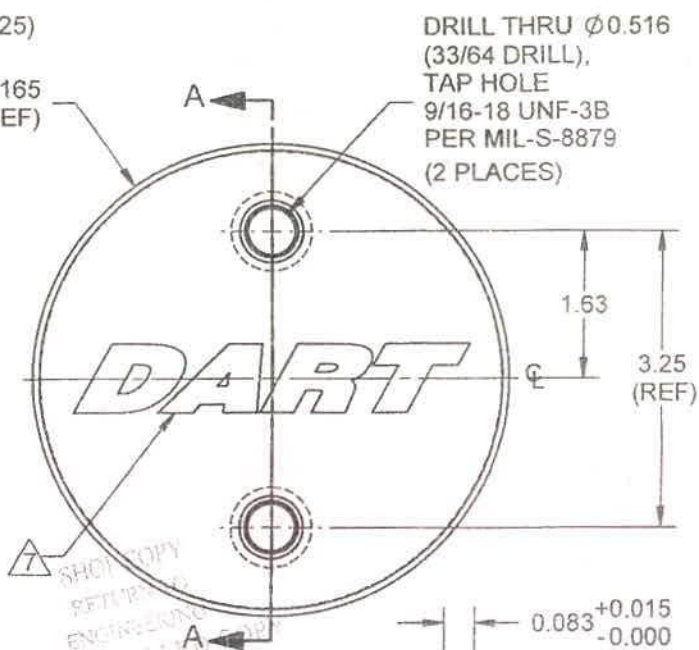
RELEASED
06.09.14

D3262-1 TUBE

- 1) MATERIAL: 6061-T6 OR 6061-T62 TUBING, 5.00 OD x 0.125 WALL
PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR
QQ-A-200/8 OR QQ-A-225/8
(REF. DART SPEC. M6061T6T5.000W.125)



SECTION A-A
SCALE 1:2



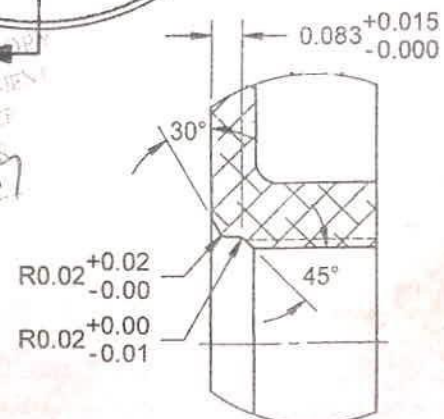
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NO. 29937

D3262-3 CAP

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) BAR
(REF. DART SPEC. M6061T6B)

NOTES:

- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS 0.005 TO 0.010
- 6) PART IS SYMMETRICAL ABOUT CENTERLINE
- 7) ENGRAVE 'DART' LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP (MAX) LETTERS WITH TOOL RADIUS OF 0.25 (MIN)



DETAIL B
SCALE 2:1

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